

Work Order ID 147021

Tuesday, November 08, 2016 7:42:45 AM

147021

Reprint

Page 1

Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: _____ Tooling: _____ Date: _____
QC: 9-89 Date: NOV 08 2016 SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2650	F(DEO)
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100	Document Control	0.00
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100

DOCUMENT CONTROL

DC

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-341 CHG005

DAS

21

9-89

N/A

NOV 08 2016

Work Order ID 147021

Tuesday, November 08, 2016 7:42:45 AM

147021

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.97							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/RAluminum Rod m132750 m135682 m134826 m134826 16-10-13								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8035.								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)								
	12-Deburr.								

Tuesday, November 08, 2016 7:42:45 AM

147021

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

1

Cust Item ID:

Start Date: 5/26/2016 **Start Qty:** 1.00

Required Date: 6/24/2016 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

115

QC

Memo

0.02

Quality Control

14-11-07

0.00

1 1 6

QC

Memo

0.00

Quality Control

0.00

1 20

HandFinish

Memo

0.46

Hand Finishing

2016/11/07

323

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 4

Item ID: D206-642-341

Accept

N900040100

Setup Start

NS1

Revision ID:

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Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC7-Inspect Chemical Conversion Coat	0.00							
125									
QC	Memo	0.01							
Quality Control									
130	Skidtubes	0.00							
130									
Skidtubes	Memo	0.37							
Skidtubes	1- Bond D2654-5 web in place as per QSI 015 Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: _____ Time: 12:30 Finish Date: _____ Time: 12:30 A/RSikaflex-291 135778 Sikaflex expiry date: 17-2-16								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
38
9-89

16-11-07

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 5

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Start Date: 5/26/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Skidtubes	Skidtubes	0.00							
	Memo	1.26							
	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
	2- Install nut plate as per dwg								
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.02							
	Quality Control								
190 *190* HandFinish	Pressure Wash per QSI005 4.3	0.00							
	Memo	0.58							
	Hand Finishing								

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 6

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>9:30</u>	0.00 0.12				<u>11</u>	<u>0</u>	<u>10-11-8</u>	<u>989</u> <u>34</u> <u>DAS</u>
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01							<u>1x</u> <u>d</u> <u>del</u> <u>10/11/08</u>

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 7

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Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220	HandFinish	Memo							
Hand Finishing	1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>M1132772</u> Sikaflex expiry date: <u>12/10/2</u> 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>M1132772</u> Sikaflex expiry date: <u>12/10/2</u> 6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: <u>M1132810</u>	1.68							<u>ln d all c e l e l o g</u>

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 8

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Start Date: 5/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				1			DAS 38 9-89 NOV 08 2016
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			DAS 38 9-89 NOV 08 2016
250 *250* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location:FG083 sold	0.00 0.00							DAS 27 9-89 NOV 08 2016

Work Order ID 147021

Tuesday, November 08, 2016 7:42:46 AM

147021

Page 9

Item ID: D206-642-341

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.10

Quality Control

DAS
21
9-89

NOV 08 2016

DAS
21
9-89

NOV 08 2016

Picklist Print

Tuesday, November 08, 2016 7:42:44 AM

Page 1

Work Order ID: 147021

147021

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 Ecn14-520 DD ver: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130	AELS4-1032-130	Purchased	No			220	Each	4,204.000	54	54			

ALS4-1032-130

Rivnut

**

10/11/08

Location	Loc Qty	Loc Code
CCK004	2364	
M135442	2364	
FG	50	FG
M135442	50	
FP001	1650	
M133077	122	
M135442	1528	
ST556	140	
M135442	140	

CCR264SS3-3

CCR264SS3-3-03

Purchased

No

Each

121.0000

CCR264SS3-3

Cherry Rivet

**

10/11/08

Location	Loc Qty	Loc Code
FP001	121	
m128818	121	

Picklist Print

Tuesday, November 08, 2016 7:42:44 AM

Page 2

Work Order ID: 147021

147021

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

149.0000

CR3212-4-03

Cherry Rivet

**

2

lll 16/11/08

Location

Loc Qty

Loc Code

CCK003

100

m134943

100

FP001

19

m126320

19

ST320

30

119017

30

D2620

Manufactured

No

Each

3.0000

D2620

Skidtube, 206 Skidtube

**

1

lll 16/11/08

Location

Loc Qty

Loc Code

LG002

3

151501

3

D2646

Manufactured

No

220

Each

59.0000

D2646

Aft Cap

**

1

lll 16/11/08

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

55

127924

1

136885

3

141214

11

149746

4

149748

36

Tuesday, November 08, 2016 7:42:44 AM

Shop Packet Print

Page 2

Picklist Print

Tuesday, November 08, 2016 7:42:44 AM

Page 3

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147021

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D2647

Manufactured No

Each

16.0000

D2647

Cap

**

1

16-10-13
B E / 16-10-13

Location

Loc Qty

Loc Code

LG001

16

136125

6

151719

10

D2651-1

Manufactured No

220

Each

218.0000

14

D2651-1

Plug

**

14

all valves

Location

Loc Qty

Loc Code

FP001

218

134571

3

136097

100

144659

65

151701

50

D2651-3

Manufactured No

220

Each

277.0000

14

D2651-3

O-Ring

**

14

all valves

Location

Loc Qty

Loc Code

FP001

277

120110

73

135359

2

141702

2

147815

200

D2654-5

Manufactured No

Each

4.0000

D2654-5

Web

**

1

all valves

Location

Loc Qty

Loc Code

LG002

4

150615

4

Tuesday, November 08, 2016 7:42:44 AM

Shop Packet Print

Page 3

Picklist Print

Tuesday, November 08, 2016 7:42:44 AM

Page 4

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D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

21.0000

**

1

D2680-041

Nut Plate

Location

Loc Qty

Loc Code

LG001

21

141543

12

150657

9

D3537-1

Manufactured No

220

Each

165.0000

6

**

6

D3537-1

Wearpad

Location

Loc Qty

Loc Code

FG

14

79833

4

88562

10

FP001

150

141922

7

147593

48

150462

34

150709

9

151518

52

ST184

1

125911

1

D3537-3

Manufactured No

220

Each

39.0000

1

**

1

D3537-3

Wearpad

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

31

141921

31

Tuesday, November 08, 2016 7:42:44 AM

Shop Packet Print

Page 4

Picklist Print

Tuesday, November 08, 2016 7:42:44 AM

Page 5

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Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4720-1

Manufactured No

150 Each

227.0000 19

D4720-1

Spacer

**

19

16-11-8

Location

Loc Qty

Loc Code

LG001

227

141321

78

146840

149

D4956-11

Manufactured No

Each

16.0000

D4956-11

Wearplate Fwd

**

1

all valves

Location

Loc Qty

Loc Code

FP001

10

141198

10

FP002

6

152004

6

D4956-23

Manufactured No

Each

19.0000

D4956-23

Wearplate Center Fwd

**

1

all valves

Location

Loc Qty

Loc Code

FP002

19

145563

7

150588

4

151705

8

D4956-35

Manufactured No

Each

23.0000

D4956-35

Wearplate Aft

**

1

all valves

Location

Loc Qty

Loc Code

FP002

23

142432

17

152003

6

Tuesday, November 08, 2016 7:42:45 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, November 08, 2016 7:42:45 AM

Page 6

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147021

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Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

Each

194.0000

MS27039-1-08

Screw

**

2
lll 11/11/16

Location

Loc Qty

Loc Code

FP001

12

m128636

12

GA

89

m128636

89

ST281

93

m135864

93

MS27039-4-06

Purchased

No

220

Each

47.0000

MS27039-4-06

Screw

**

1
lll 11/11/16

Location

Loc Qty

Loc Code

FP001

42

m132317

42

ST279

5

m126534

5

MS27039C1-08

Purchased

No

Each

567.0000

MS27039C1-08

SCREW

**

54
lll 11/11/16

Location

Loc Qty

Loc Code

FP001

243

m135127

3

m135979

240

ST277

324

m134955

74

m135744

250

44
10

Tuesday, November 08, 2016 7:42:45 AM

Shop Packet Print

Page 6

Picklist Print

Tuesday, November 08, 2016 7:42:45 AM

Page 7

Work Order ID: 147021

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Start Date: 5/26/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

220

Each

4,382.000

54

54

NAS1149C0332R

WASHER

ll 10/11/08

Location

Loc Qty

Loc Code

FP001

1048

m135672

84

m135948

964

GA

86

m133284

86

ST260a

2072

m135466

1000

m135672

572

m136042

500

ST266

1176

m135408

476

m135766

500

m135908

200

*18
36*

NAS1149D0332J

Purchased

No

220

Each

1,980.000

2

2

NAS1149D0332J

Washer

ll 10/11/08

Location

Loc Qty

Loc Code

FP001

174

m134848

174

GA

204

m134848

204

ST260a

1200

m136015

1200

ST264

402

m135672

402

Tuesday, November 08, 2016 7:42:45 AM

Shop Packet Print

Page 7

Picklist Print

Tuesday, November 08, 2016 7:42:45 AM

Page 8

Work Order ID: 147021

147021

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Start Date: 5/26/2016

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Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

3,931.000

1

NAS1149D0463.J

**

Washer

all 6/4/16

Location

Loc Qty

Loc Code

cnc

200

M135671

200

GA

103

M134508

32

M135056

71

ST260a

1600

M136044

1600

ST263

2028

M135530

30

M135671

3

M135767

995

M135948

1000